Work Order ID 68747

Thursday, April 21, 2011 8:20:49 AM

Item ID: D350-764-011 **Accept** **Setup Start**

Revision ID:

Item Name: Shoulder Harness **Stop**

Start Date: 4/20/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 4/25/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** 11-04-21 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
IIN-D350-764	Rev B - U/R	11.04.25							
100	DOCUMENT CONTROL	0.00							
DC	**Memo**	0.00							
Document Control	Photocopy bluefile & type labels per PPP D350-764-011		CHG002						
110	Pick Kit	0.00							
Packaging	Packaging								
Packaging	**Memo**	0.00							
120	QC4- 100% Inspect kits for completeness	0.00							
QC	**Memo**	0.00							
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID 68747

Thursday, April 21, 2011 8:20:49 AM

Item ID: D350-764-011 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Shoulder Harness

Start Date: 4/20/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 4/25/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00				11/4/29			
Packaging	**Memo**	0.00							
Packaging	Identify and pack for shipping as per PPP D350-764-011 Location: 52 PPP Rev: C								
140	QC21- Final Inspection - Work Order Release	0.00				11/4/29			
QC	**Memo**	0.00							
Quality Control									

11-04-29

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Picklist Print

Thursday, April 21, 2011 8:20:56 AM

9

Work Order ID: 68747

Parent Item: D350-764-011

Parent Item Name: Shoulder Harness

Start Date: 4/20/2011 **Required Date:** 4/25/2011

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP REV:A New issue 07-10-11 DD verified by EC
IPP Rev:B ECN 1050 rev.B as per dwg 08-01-10 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS4-1032-130		Purchased	No			110	Each	1,950.000	16	16			
Insert													
				Location			**Loc Qty**	**Loc Code**					
				ST281			1950						
					117331		1950						
AN3-3A		Purchased	No			110	Each	176.0000	32	32			
Bolt													
				Location			**Loc Qty**	**Loc Code**					
				ST350			176						
					116924		176						
AN3-6A		Purchased	No			110	Each	428.0000	16	16			
Bolt													
				Location			**Loc Qty**	**Loc Code**					
				ST351			428						
					116191		28						
					116704		100						
					117441		300						
AN4-10A		Purchased	No			110	Each	93.0000	4	4			
Bolt													
				Location			**Loc Qty**	**Loc Code**					
				ST356			93						
					116419		43						
					117313		50						

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Picklist Print

Thursday, April 21, 2011 8:20:56 AM

Work Order ID: 68747

Parent Item: D350-764-011

Parent Item Name: Shoulder Harness

Start Date: 4/20/2011 **Required Date:** 4/25/2011

Start Qty: 1.00 **Required Qty:** 1.00

AN960JD10	NAS1149D0363J	Purchased	No	110	Each	0.0000	48	48	M116583 2x
Washer									
AN960JD916		Purchased	No	110	Each	0.0000	4	4	M115204 M116683
WASHER		NAS1149D0963J							
AN970-6		Purchased	No	110	Each	42.0000	4	4	
Washer									

Location	Loc Qty	Loc Code
ST349	42	
116419	42	

CCR264SS3-3		Purchased	No	110	Each	155.0000	16	16	
Cherry Rivet									

Location	Loc Qty	Loc Code
FP-B	2	
113973	2	
ST311	153	
113973	2	
117086	151	

CR3212-4-2		Purchased	No	110	Each	107.0000	4	4	M116658
Cherry Rivet									

Location	Loc Qty	Loc Code
ST311	107	
110806	7	
112794	100	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Picklist Print

Thursday, April 21, 2011 8:20:57 AM

Work Order ID: 68747

Parent Item: D350-764-011

Parent Item Name: Shoulder Harness

Start Date: 4/20/2011 **Required Date:** 4/25/2011

Start Qty: 1.00 **Required Qty:** 1.00

CR3212-5-04 Rivet	Purchased	No		110	Each	80.0000	4	4

Location	Loc Qty	Loc Code
ST312	80	
112082	80	

CR3212-5-07 Rivet	Purchased	No		110	Each	64.0000	4	4

Location	Loc Qty	Loc Code
ST312	64	
114551	64	

D2854 3/4" Velcro Strip	Manufactured	No		110	f	42.3340	2.666	2.666

Location	Loc Qty	Loc Code
ST415	42.334	
65116	42.334	

(4X) 8.00" per dwg D2854-1/-3-080

D3578-041 Doubler	Manufactured	No		110	Each	53.0000	16	16

Location	Loc Qty	Loc Code
ST245A	53	
65269	3	
68204	50	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, April 21, 2011 8:20:57 AM

Work Order ID: 68747

Parent Item: D350-764-011

Parent Item Name: Shoulder Harness

Start Date: 4/20/2011 **Required Date:** 4/25/2011

Start Qty: 1.00 **Required Qty:** 1.00

D3636-041 Shoulder Harness	Manufactured	No		110	Each	4.0000	4	4	
			Location		**Loc Qty**	**Loc Code**			
			ST266		4				
			66116		4				
D3637-041 Bracket Assembly	Manufactured	No		110	Each	15.0000	4	4	
			Location		**Loc Qty**	**Loc Code**			
			ST245A		15				
			66859		15				
D3637-3 Bracket	Manufactured	No		110	Each	2.0000	4	4	B 6 836920
			Location		**Loc Qty**	**Loc Code**			
			ST245A		2				
			64768		2				
D3638-1 Bushing	Manufactured	No		110	Each	18.0000	4	4	
			Location		**Loc Qty**	**Loc Code**			
			ST244		18				
			64305		6				
			67013		12				
D3639-1 Doubler	Manufactured	No		110	Each	5.0000	1	1	11/4/26
			Location		**Loc Qty**	**Loc Code**			
			ST244		5				
			64820		5				

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Picklist Print

Thursday, April 21, 2011 8:20:58 AM

Work Order ID: 68747

Parent Item: D350-764-011

Parent Item Name: Shoulder Harness

Start Date: 4/20/2011 **Required Date:** 4/25/2011

Start Qty: 1.00 **Required Qty:** 1.00

D3639-2	Manufactured	No		110	Each	8.0000	1	1
Doubler								

Location	Loc Qty	Loc Code
ST244	8	
64823	8	

D3639-3	Manufactured	No		110	Each	8.0000	1	1
Doubler								

Location	Loc Qty	Loc Code
ST244	8	
64824	8	

D3639-4	Manufactured	No		110	Each	8.0000	1	1
Doubler								

Location	Loc Qty	Loc Code
ST244	8	
58830	1	
64819	7	

D3640-1	Manufactured	No		110	Each	4.0000	2	2
Belt Guide								

Location	Loc Qty	Loc Code
ST244	4	
66768	4	

D3640-3	Manufactured	No		110	Each	4.0000	2	2
Belt Guide								

Location	Loc Qty	Loc Code
ST243	4	
66769	4	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Picklist Print

Thursday, April 21, 2011 8:20:58 AM

Work Order ID: 68747

Parent Item: D350-764-011

Parent Item Name: Shoulder Harness

Start Date: 4/20/2011 **Required Date:** 4/25/2011

Start Qty: 1.00 **Required Qty:** 1.00

D3641-1 Cover	Manufactured	No	110	Each	4.0000	2	2	

Location	Loc Qty	Loc Code
ST260	4	
64812	4	

D3641-3 Cover	Manufactured	No	110	Each	7.0000	1	1	

Location	Loc Qty	Loc Code
ST260	7	
64817	7	

D3641-4 Cover	Manufactured	No	110	Each	6.0000	1	1	

Location	Loc Qty	Loc Code
ST260	6	
64818	6	

D3642-1 Doubler	Manufactured	No	110	Each	9.0000	2	2	

Location	Loc Qty	Loc Code
ST244	9	
64306	9	

D3643-1 Stiffener	Manufactured	No	110	Each	6.0000	1	1	11/4/2011

Location	Loc Qty	Loc Code
ST244A	6	
58834	1	
60580	5	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr.	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, April 21, 2011 8:20:58 AM

Work Order ID: 68747

Parent Item: D350-764-011

Parent Item Name: Shoulder Harness

Start Date: 4/20/2011 **Required Date:** 4/25/2011

Start Qty: 1.00 **Required Qty:** 1.00

D3643-2 Stiffener	Manufactured	No		110	Each	2.0000	1		
			Location		**Loc Qty**	**Loc Code**			
			ST244A		2				
			58350		2				
D3644-1. Shim	Manufactured	No		110	Each	10.0000	2	2	
			Location		**Loc Qty**	**Loc Code**			
			ST244A		10				
			66776		10				
D3657-1 Guide Tool	Manufactured	No		110	Each	9.0000	1	1	
			Location		**Loc Qty**	**Loc Code**			
			ST244A		9				
			64821		9				
MS20426AD3-3 Rivet	Purchased	No		110	Each	2,867.000	32	32	
			Location		**Loc Qty**	**Loc Code**			
			ST316		2867				
			19099		2867				
MS20426AD4-4 Rivet	Purchased	No		110	Each	3,041.000	106	106	11/4/2011
			Location		**Loc Qty**	**Loc Code**			
			ST317		3041				
			116188		3041				

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, April 21, 2011 8:20:59 AM

Work Order ID: 68747

Parent Item: D350-764-011

Parent Item Name: Shoulder Harness

Start Date: 4/20/2011 **Required Date:** 4/25/2011

Start Qty: 1.00 **Required Qty:** 1.00

MS20426AD4-6	Purchased	No	110	Each	1,204.000	28	28	
Rivet								

Location	Loc Qty	Loc Code	
ST317	1204		
110139	1204		28

MS20470AD4-6	Purchased	No	110	Each	3,245.000	8	8	
Rivet, Universal Head								

Location	Loc Qty	Loc Code	
ST319	3245		
116391	215		8
117395	3030		

MS21059L3	Purchased	No	110	Each	66.0000	16	16	
Nut Plate								

Location	Loc Qty	Loc Code	
ST301	60		
117423	60		16
ST302	6		
116706	6		

MS21072-L3	Purchased	No	110	Each	54.0000	8	8	11/4/26
Nutplate								

Location	Loc Qty	Loc Code	
ST302	50		
117343	50		4
ST303	4		
116188	4		4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

Thursday, April 21, 2011 8:20:59 AM

Work Order ID: 68747

Parent Item: D350-764-011

Parent Item Name: Shoulder Harness

Start Date: 4/20/2011 **Required Date:** 4/25/2011

Start Qty: 1.00 **Required Qty:** 1.00

MS35207-267 Screw	Purchased	No	110	Each	98.0000	8	8	11/4/26

Location	Loc Qty	Loc Code
ST295	98	
117395	98	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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5.0 PARTS LISTS

QTY -011	Dart Part Number	Geneva Part Number	Description
X	**D350-764-011**	**P131**	**Shoulder Harness Kit**
4	D2854-1-080	N/A	VELCRO STRIP
4	D2854-3-080	N/A	VELCRO STRIP
16	D3578-041	N/A	DOUBLER
4	D3636-041	N/A	SHOULDER HARNESS
4	*D3636-11	G10601-2	SHOULDER BELT
4	*D3636-13	G10601-4	LAP BELT
4	D3637-041	G10602-1	BRACKET ASSEMBLY
4	D3637-3	G10609-1	BACKER PLATE
4	D3638-1	G10608-2	BUSHING
1	D3639-1	G10604-3	DOUBLER
1	D3639-2	G10604-6	DOUBLER
1	D3639-3	G10604-4	DOUBLER
1	D3639-4	G10604-5	DOUBLER
2	D3640-1	G10605-1	BELT GUIDE
2	D3640-3	G10605-2	BELT GUIDE
2	D3641-1	G10606-3/-6	COVER
1	D3641-3	G10606-5	COVER
1	D3641-4	G10606-4	COVER
2	D3642-1	G10607-1/-2	DOUBLER
1	D3643-1	G10610-2	STIFFENER
1	D3643-2	G10610-1	STIFFENER
2	D3644-1	G10610-3	SHIM
1	D3657-1	G12170	GUIDE TOOL
16	ALS4-1032-130	N/A	INSERT
32	AN3-3A	N/A	BOLT
16	AN3-6A	N/A	BOLT
4	AN4-10A	N/A	BOLT
48	AN960JD10	N/A	WASHER
4	AN960JD916	N/A	WASHER
4	AN970-6	N/A	WASHER
16	CCR264SS-3-03	N/A	RIVET
4	CR3212-4-02	N/A	RIVET
4	CR3212-5-04	N/A	RIVET
4	CR3212-5-07	N/A	RIVET
32	MS20426AD3-3	N/A	RIVET
106	MS20426AD4-4	N/A	RIVET
28	MS20426AD4-6	N/A	RIVET
8	MS20470AD4-6	N/A	RIVET
16	MS21059L3	N/A	NUTPLATE (OR MS21059-3)
8	MS21072L3	N/A	NUTPLATE (OR MS21072-3)
8	MS35206-267	N/A	SCREW

*Included with D3636-041

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